January-24-13 11:57:10 AM Item ID: D3237-1-0980 Accept *N900040100* Setup Start **Revision ID:** Item Name: Seal **Start Date: Start Qty: 10.00** *10* 1/24/13 **Cust Item ID:** Required Date: 2/07/13 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Process Plan: MLJ Date: 13 01-24 Tooling: Approvals: Date: Stop _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp Draw Nbr **Revision Nbr** D3237 Rev B 100 0.00 Small Fab *100* Small Fab 0.00 Memo Small Fab Cut as per dwg D3237 (98" long) 110 QC5- Inspect part completeness to step on W/O *110* Memo Quality Control Identify as per dwg & Stock Location: 120 0.00 *120* Packaging 0.00 Memo Packaging

DQA: ____ Date: _

NCR:	Yes	/ No				1	WORK ORDER NON-O	CON	VFORM	MANCE / UP	DATE						
		, ,,,,,								•		QA Closed:	Date:				
Work Order:							DISPOSITION			AGAINST DEPARTMENT/PROCESS							
VOIR OIG	C1.					-	Rework]		Skid-tube Crosstube		Water Jet		Engineering			
Part	No.						Scrap]		Machining	Small Fab	-1	d. Eng. Coor.	Quality			
							Use-as-is			noforming	Finishing	Rec/Stor	e/Packaging	Other			
NCR	No.						Work Order Update	١		Large Fab	Composite] .	Supplier	J			
Root					Dé	scri	ption of work order update	1	nitial	Ac	tion	Sign &					
Cause		Date	Step	Qty			or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector			
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	_	Bending				Г	Bend		Grain			Ovalized		Pressure/Forced			
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		Cracks				Г	Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld			
	Г	Crushed/	Crimped.				Burrs			ions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
		Cuffs					Contamination		Mainte	nance		Part Moved					
Heat Treat			Countersink		Mislabe	eled		Positioned V	Vrong	<u></u>							
		Inspection	n Strip in	Tube			Cut Too Short		Misread	i	. [_	Power Loss/	Surge	Other			
		Ripples in	Bend		1.		Drill Holes		Offset								
		Torque W	/aves in [Extrusio	n		Drawing		Out of (Calibration							
		Turning S	equence				Finish	L	Out of 9	Sequence							
Wave/Twist in Tube						Folio		Outside	Dimensions								

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January-24-13 11:57:10 AM Item ID: D3237-1-0980 Revision ID: Item Name: Seal Start Date: 1/24/13

Accept

N900040100

Setup Start

Required Date: 2/07/13

Start Qty: 10.00 Req'd Qty: 10.00 *10* *10*

Cust Item ID:

Customer:

Reference:

Quality Control

Approvals:	Process Plan:	Date:	Tooling: SPC (Y/N):		nte:		F	Run Sta Sto	" "I V	R1* R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Insp	ection - Work Order Release	0.00							
130	Men	no	0.00					ML5	130	19-29

MCJ (3052

NCR: Yes / No							WORK ORDER NON-CONFORMANCE / UPDATE										
						Ļ	.			· · · · · · · · · · · · · · · · · · ·	QA Closed:	Date:					
Nork Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS										
Part f	۷o.						Rework Scrap		Skid-tube Crosstube Machining Small Fab			_	Water Jet d. Eng. Coor.	Engineering Quality			
NCR f	No.				··		Use-as-is Work Order Update		Thermoforming Finishing Composite			Rec/Store/Packaging Other Supplier					
Root	-				De	scri	ption of work order update		nitial	Ac	ction	Sign &					
Cause		Date	Step	Qty		1	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector			
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Landi	ng (Gear		Ì	Ì		General										
		Bending					Bend		Grain			Ovalized		Pressure/Forced			
	Г	Centre No	t Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under tolerance		Temperature/Cure			
	Γ	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld			
		Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
Cuffs			Contamination		Mainte	nance		Part Moved		-							
	Heat Treat			Countersink		Mislabe	led		Positioned V	√rong							
Inspection Strip in Tube			Cut Too Short		Misread	I		Power Loss/	Surge	Other							
		Ripples in	•				Drill Holes		Offset		_						
		Torque W		xtrusio	n		Drawing		Out of (Calibration							
		Turning Se					Finish			equence				1			
		Wave/Twi					Folio	T	1	Dimensions							

DQA:

Date:

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Picklist Print

January-24-13 11:57:14 AM

Work Order ID: 96346

D3237-1-0980

Parent Item Name: Seal

96346

D3237-1-0980

Start Date: 1/24/13

Required Date: 2/07/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

Parent Item:

IPP REV:A 11.04.26 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3237-1		Manufactured	No			100	f	342.5598	8.1666	85.96421		- 7 1
D3237-1 Seal Retainer									** (9	2	1	315/29
				Location		Loc (<u>Oty</u>	Loc Code	/ .	_	Ċ	()
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				3	32825		131					`
		•		4 سسر	3183	(9.84					

201.719789

NCR: Yes / No							WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:										
Work Orde	r:						DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part No.				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other						
NCR N	o					-	Work Order Update		1	Large Fab	Composite		Supplier				
Root		Ţ			D	escri	ption of work order update		nitial	Ac	tion	Sign &					
Cause		Date	Step	Qty] ,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector			
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upplier																	
raining																	
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					1		FAULT CATEGORY										
Landin	g G	ear		- · ·	Í	-	General		_					_			
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ļ	\neg	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld			
ľ		Crushed/C	Crimped.				Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
Cuffs			Contamination		Mainte	nance	Γ	Part Moved									
	٦,	Heat Treat	t				Countersink		Mislabe	led		Positioned V	Vrong	_			
ľ	Inspection Strip in Tube			Cut Too Short	Г	Misread	I		Power Loss/	Surge	Other						
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<u> </u>	_	Wave/Twi		e	- 1		Folio		Outside	Dimensions							

DQA:

Date:

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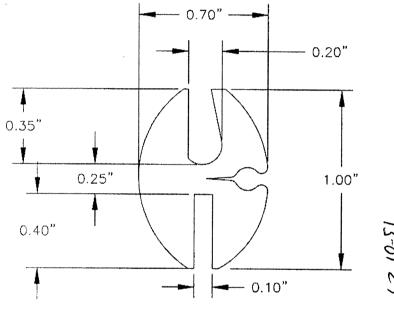




DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED,	DRAWING NO. REV. B
9	T H	D3237 SHEET 1 OF 1
DATE		TITLE SCALE
04.05.	05	SEAL NTS
Α	04.01.22	NEW ISSUE
В	04.05.05	REMOVE (REF) & ADD QSI 018

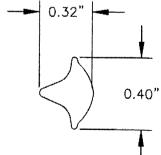


SPECIFICATION CONTROL DRAWING



D3237-1-XXXX SFAL RETAINER
WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES EG. 98.0" LONG EQUALS D3237-1-0980

PURCHASE: MILL SUPPLY, INC. P/N R-1025 TOLERANCES PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES EG. 98.0" LONG EQUALS D3237-3-0980

PURCHASE: MILL SUPPLY, INC. P/N R-1029 TOLERANCES PER DART QSI 018 UNLESS OTHERWISE **SPECIFIED**

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